

Work Order ID 67807

Thursday, March 31, 2011 8:56:20 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4373-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Screw

Start Date: 3/31/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 2.00



Customer:



Reference:

See 11-03-31

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4373	PA1

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

TURN AS PER DWG
DWG REV: *PA1*

DEBURR

0.00

See 11-3-31

2

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

See 11-3-31

2

120

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

See 11-03-31

2 0

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Page 2

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Start Date: 3/31/2011 Start Qty: 2.00

Required Date: 4/1/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:



Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
 Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
 QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE 11/03/11 AUTH le

RELEASED _____ DATE _____

RD1370mer.

Picklist Print

Page 1

Thursday, March 31, 2011 8:56:16 AM

Work Order ID: 67807



Parent Item: D4373-3



Parent Item Name: Screw


Start Date: 3/31/2011

Required Date: 4/1/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV: A NEW ISSUE 11-03-31 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174R0.750 		Purchased					f	8.0000		0.349474		11.3.31	
17-4 round bar .750													

LocationLoc QtyLoc Code

MAT030

8

116808

8

350

DART AEROSPACE LTD		Work Order: 67807
Description: Screw		Part Number: 14373
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

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First Article

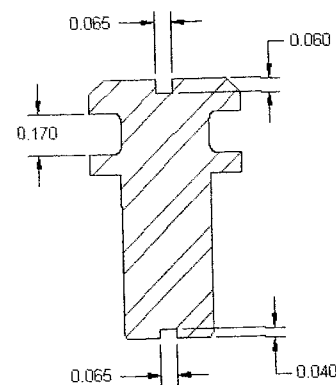
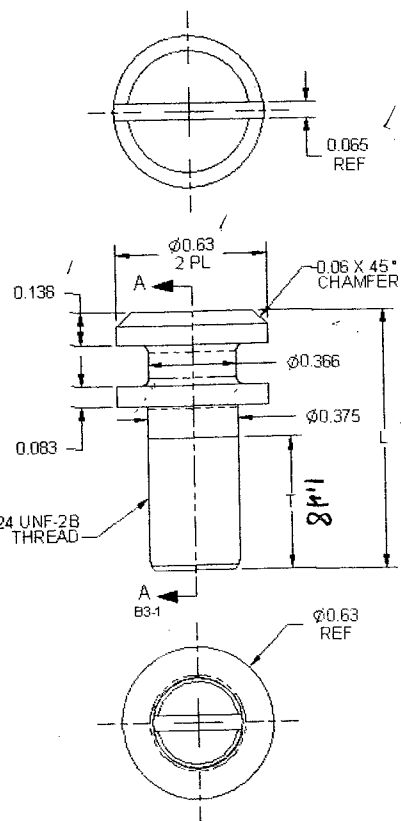
☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.065 \pm	\pm .030	.063	/		RQ .02	
.63 ϕ	\pm .030	.630	/			
.06 x 45°	\pm .030	.055	/			
.138	\pm .010	.136	/			
.366 ϕ	\pm .006 - .0.0	.366	/			
.083	\pm .010	.085	/			
.375	\pm .010	.370	/			
2.00	\pm .030	2.000	/			
1.48	\pm .030	1.504	/			
3/8-24	2A	2A	/			
Major ϕ	.3739 / .3667	.370	/		RQ .06	
M.O.W.	.3977 / .3939	.396	/		RQ .06	
.065 \pm	\pm .010	.063	/		RQ .02	
.060	\pm .010	.060	/			
.170	\pm .010	.169	/			
.065	\pm .010	.063	/			
.040	\pm .010	.039	/			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date:	Date: 11.03.21	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



SECTION A-A B5-1

PART NUMBER	L	T (THREAD LENGTH)
D4373-1	1.08	0.55
D4373-3	2.00	1.48

D4373-X

**PRELIMINARY
ISSUE**

NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL ROUND BAR
PER AMS 5643
REF DART SPEC. M17-4-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 & 1
- 7) WEIGHT: 0.04

PA1	NEW ISSUE	RF	11.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
DRAWN	DC	DRAWING NO.	REV. PA1
CHECKED	DC	D4373	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		FLOOR HARDWARE	NTS
DE APPR.		COPY RIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PREPARED FOR THE USE OF THE CUSTOMER AND IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	11.03.29		